

Date: Tuesday, 1/16/2007 11:28:50 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT ASSEMBLY  
 Job Number : 30276  
 Estimate Number : 10464  
 P.O. Number : *N/A*  
 This Issue : 1/16/2007 S.O. No. : *N/A*  
 Prsht Rev. : NC  
 First Issue : *N/A* Type : SMALL /MED FAB  
 Previous Run : 30150  
 Part Number : D3278041  
 Drawing Number : D3278 REV. B  
 Project Number : N/A  
 Drawing Revision : B  
 Material : *N/A*  
 Due Date : 1/26/2007 Qty: 40 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est:A 04.04.19 New issue KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 30276A SUPPORT



Comment: Sub-Component SUPPORT

D3278-1 B *B 30276 A*

*x 40*

*ml 07/02/21*

2.0 30276B SUPPORT



Comment: Sub-Component SUPPORT

D3278-2 B *30150 B*

*x 6*

*B 30276 B x 34*

*ml 07/02/21*

3.0 D32783 Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Spacer

Pick:

Qty Part Number Description Batch

1 D3278-3 Spacer *B 30291 x 40*

*ml 07/02/21*

4.0 MS20426AD37 RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)

RIVET

Pick:

Qty Part Number Description Batch

4 MS20426AD37 Rivet *M16527*

*can not take out from inv.*

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet spacers with support as per Dwg D3278.

*ml 07/02/21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: SUPPORT ASSEMBLY

Job Number: 30276

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/02/21

40

7.0

D22301

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Mounting Lug

Pick: Packing Kit

Qty Part Number

2 D2230-1

Description

Mounting Lug

Batch

B29377

X17

B30155 X63

Not in system

8.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4-13A

Description

Bolt

Batch

M101149 X2

M103177 X78

9.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

4 AN960JD416

Description

Washer

Batch

M103338 X144

M100575 X16

10.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

2 MS21042L4

Description

Nut

Batch

M19085 X6

M103349 X74

ml 07/02/23

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

\*\*\*DO NOT TIGHTEN BOLTS\*\*\*

Identify as D3278-041

X40

ml 07/02/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/02/27

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:28:50 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 30276

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/02/23

40

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 571.5

07/2/26 40

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

40  
07/02/27

Job Completion



4 07-02-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

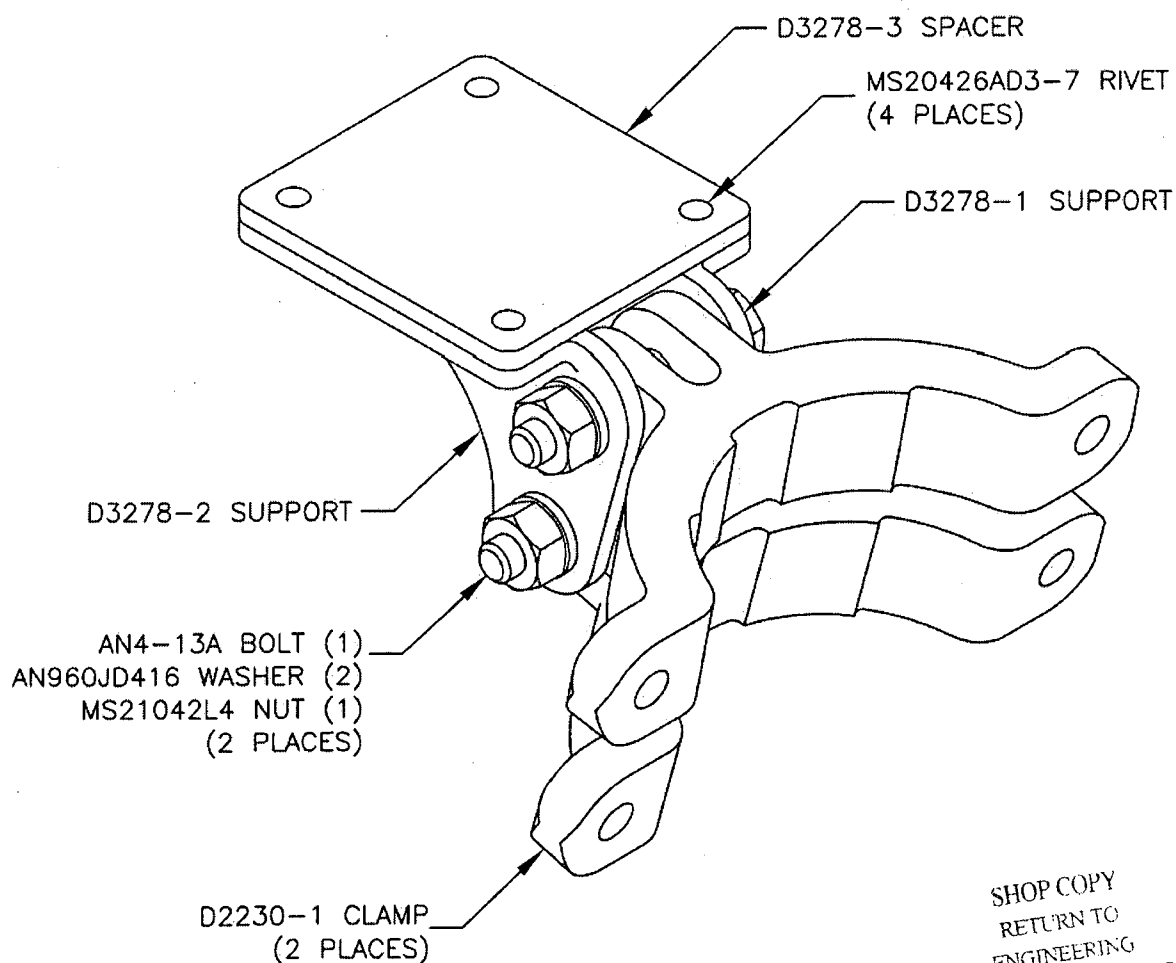
**NOTE:** Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

RELEASED  
05.04.04 *[Signature]*

## D3278-041 SUPPORT ASSEMBLY



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WORK ORDER  
NO. 30276

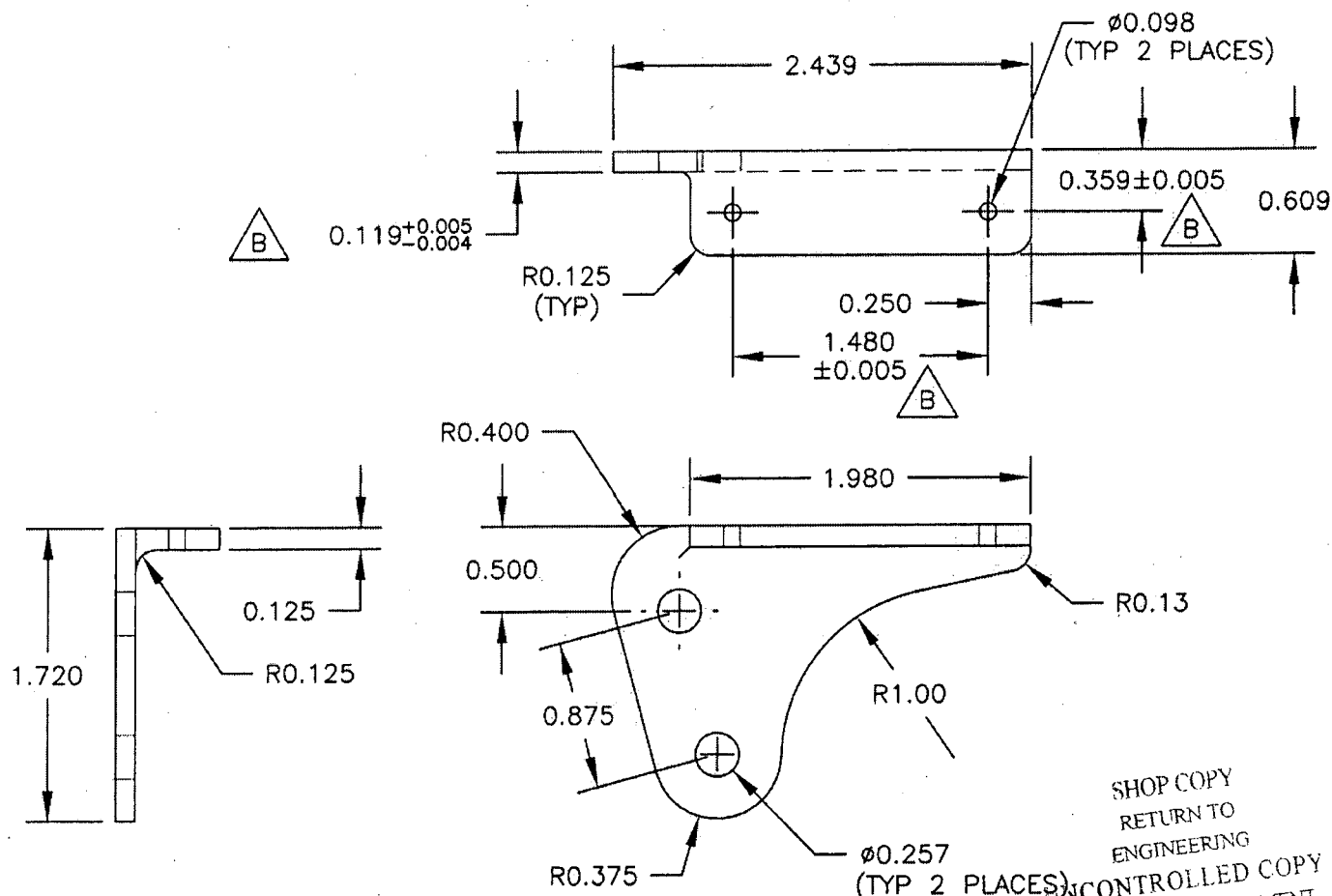
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[Signature]*

D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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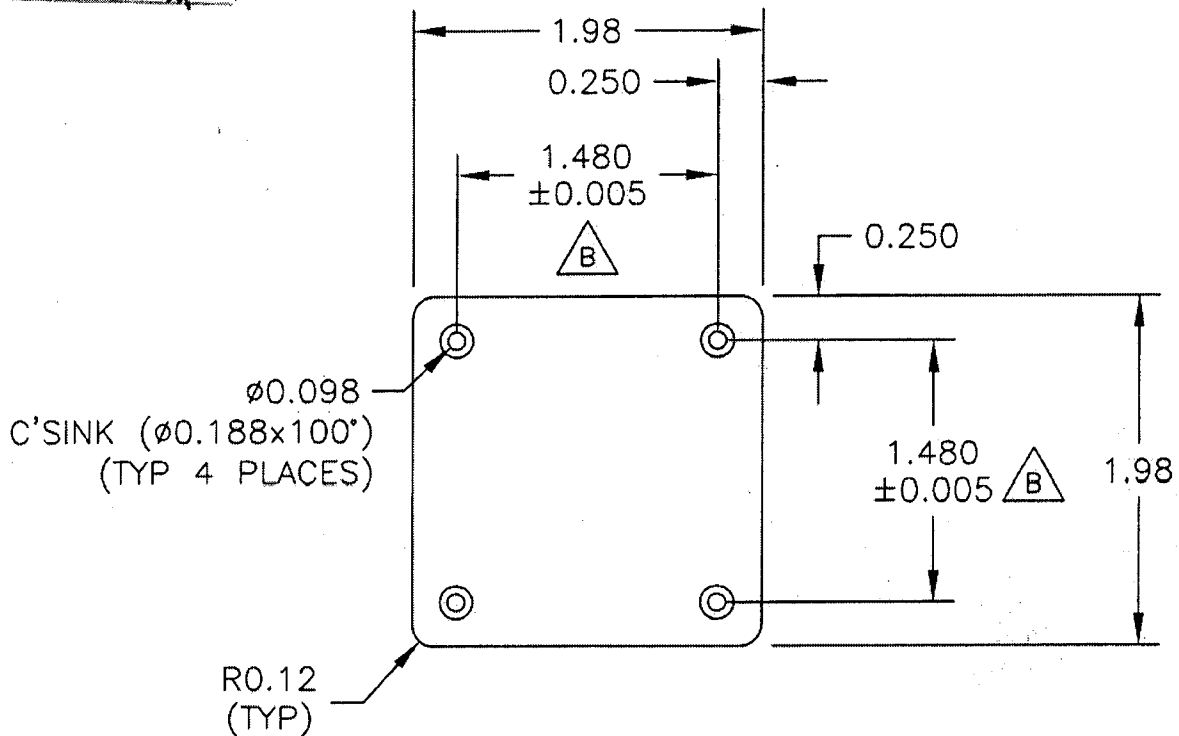
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[Signature]*

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NO. 30276

**D3278-3 SPACER**

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S  
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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